

Date: Wednesday, 5/16/2007 1:29:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 D34583 PLATE



Comment: Qty.: 2,0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-3 Plate

Batch 31074=8

307



SL.07.05.81

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102756
M103317

Grind end cap welds flush

07.06.01 ④

SL

SL 07.06.01 4

SL 07.06.01 4

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

(LH)

NOTOK/OK 13

8.0 QC5 INSPECT WORK TO CURRENT STEP



07.06.05 ④

LH

Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005.4.1

Kim

07.06.07

4

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



07.06.07 ④

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SL 07.06.11

Form: M100388

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Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig DT
A/R AL ROD Batch: M102756

PL-07-06-11

Grind per dwg D2724

fl-a.m

07.06.12

12.0

QC5/9



WELD INSPECTION

QC5/9-07-06-13 ④



Comment: WELD INSPECTION

LH

07/06/13

13.0

HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M.F

07/06/16

L

Touch up Alodine

14.0

SPRAY PAINTING



SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

Atelier
Debossed 296

fl
4034

c207/06/25 ①

-PAINT DELFLEET BLUE (PER QSI 005)

-CLEAR DELFLEET

15.0 QC14



INSPECT SPRAY PAINT

Jes-06-22 ①



Comment: INSPECT SPRAY PAINT

16.0

HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m/04733



07/06/25 ①

17.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

Jes-06-26 ①



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PL 32391

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Job Number:



Seq. #: Machine Or Operation:

Description:

19.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

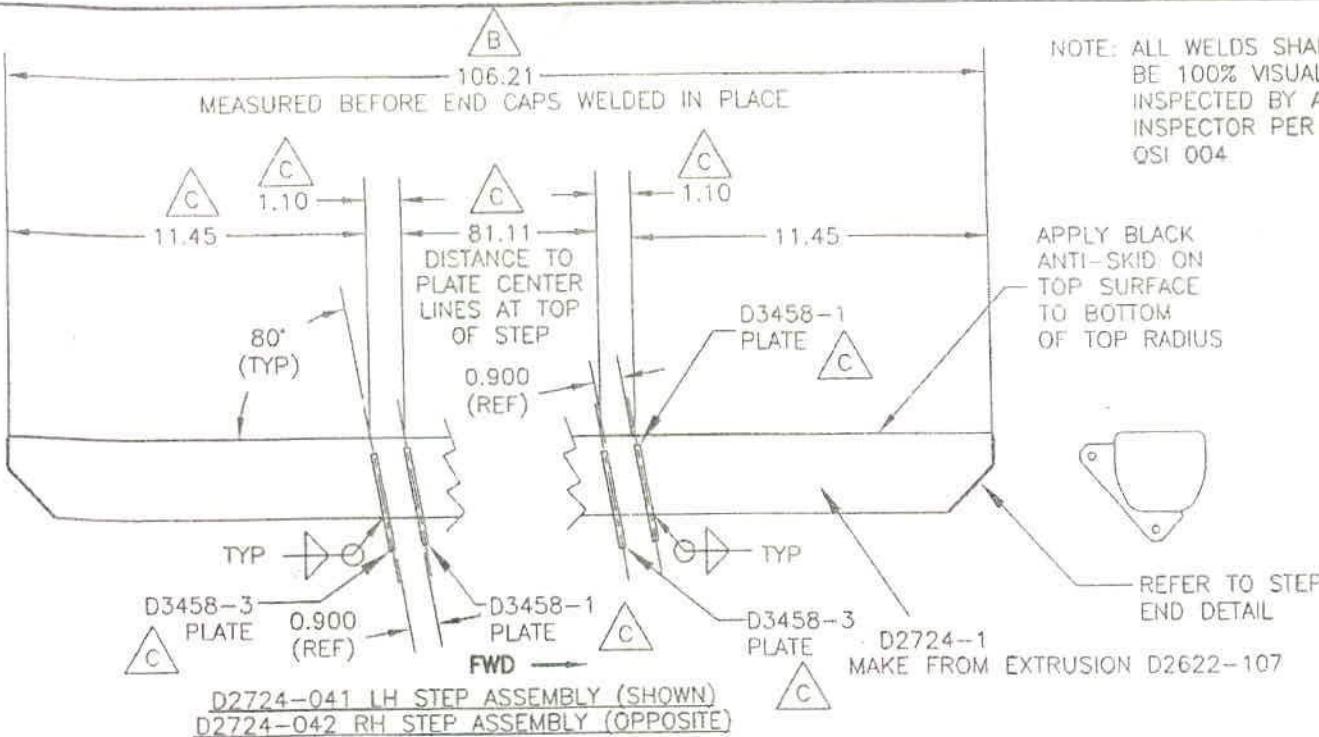
Comment: FINAL INSPECTION/W/O RELEASE

107106126

Job Completion



U 07.06.26



D2721-041/-042 STEP ASSEMBLY PARTS LIST

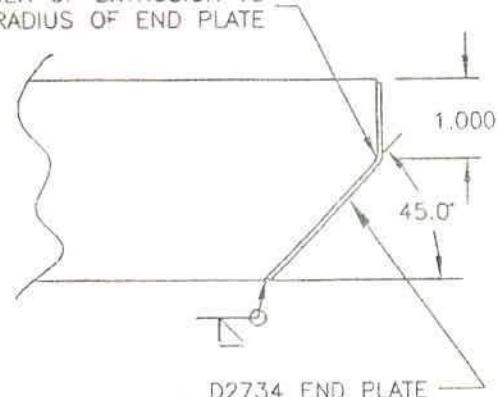
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDFR COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SOFT COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
DRAFT COPY
NOT FOR FURTHER USE
32391A

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.
		PORT HADLOCK, WA
05.09.19	97.12.04	DRAWING NO.
A		D2724
B	98.10.19	REV. C
C	05.09.19	1 OF 1
		SCALE
		NTS
		TITLE
		206L/407 STEP ASSEMBLY